Date: User: Friday, 17/10/2008 12:42:25 PM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 42713

Estimate Number

: 10501

P.O. Number

: 17/10/2008 This Issue

: NC

Prsht Rev. : 17

First Issue **Previous Run**

: 39242

Type

S.O. No. :

: SMALL /MED FAB

Part Number

Drawing Name

: D2744

: C

Drawing Number

: D2744 REV C : N/A

: FORWARD CAP

Project Number Drawing Revision

Material

: 15/11/2008 **Due Date**

40 Um:

Each

Written By

Checked & Approved By

Comment

Est Rev:D Now on Waterjet 06-06-16 JLM

As per Rev C Est Rev:E

07-07-28 JLM

Verified By:

Additional Product

Job Number:



0.1914 sf(s)/Unit

Seq. #:

Machine Or Operation:

Description:

5052-H32 .080 Sheet

1.0

M5052H32S080

pulled Total: 7.6566 sf(s)

Material: 5052-H32 (QQ-A-250/8) of 6061-T6 (QQ-A-250/11) 0.080 thick.

Use off-cuts

M5052H32S.080) Batch

108433

2.0

WATER JET

Comment: Qty.:

Comment: FLOW WATER JET

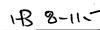
1-Cut as per Dwg D2744

Dwg Rev:__

1B8-11-7

Prog Rev:__

2-Deburr if necessary



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



4B 8-11-7



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

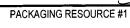
4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0 PACKAGING 1





Comment: PACKAGING RESOURCE #1

Identify and Stock BARCA Y



Dart Aerospace L

	12								
W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	tegory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositi	ion:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section			Verification		Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		Section C	Chief Eng	QC Inspector
		·							
					i				

NOTE: Date & initial all entries

Date: User: Friday, 17/10/2008 12:42:25 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD CAP

Job Number: 42713

Part Number: D2744

Job Number:



Seq. #:

Job Completion

Machine Or Operation:

Description:

6.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

FINAL INSPECTION/W/O RELEASE



Dart Aerospace Ltd

W/O:				· · · · · · · · · · · · · · · · · · ·				
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·								
Part No		PAR #:	Fault Category:	NCR: Yes			Date:	

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B			Anneaual	
DATE	TE STEP Description of NC Section A		Initial Action Description Sign & Chief Eng Chief Eng Date		Verification Section C	Approval Chief Eng	Approval QC Inspecto	
							·	
								. ,

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42713
Description: Cap	Part Number: D2744
Inspection Dwg: D2744 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.02	+/-0.030	3.010	X			
6.52	+/-0.030	6.513	×			
3.26	+/-0.030	3.765				
		····				
	~					
			·			
				:		
-						
						·
					,	
			1			

Measured by:	R	Audited by:	Prototype Approval:	N/A
Date:	8-11-7	Date: OSuio	Date:	N/A

Rev	Date	Change	Revised by	Approved
A (03.12.15	New Issue	KJ/RF .	
В	04.06.22	Dimension 6.52 was 6.27	KJ/RF	
CC	07.09.06	3.26 dimension added	KJ/JLM A	U



DESIG	N #	DRAWN BY		OSPACE USA, INC. DRT HADLOCK, WA
CHECK	₽ D∏	APPROVED	DRAWING NO.	REV. C
ر ا	Merik	TIT	D2744	SHEET 1 OF 1
DATE			TITLE	SCALE
	06.1	10.05	CAP	1:1
REV		DATE		DESCRIPTION

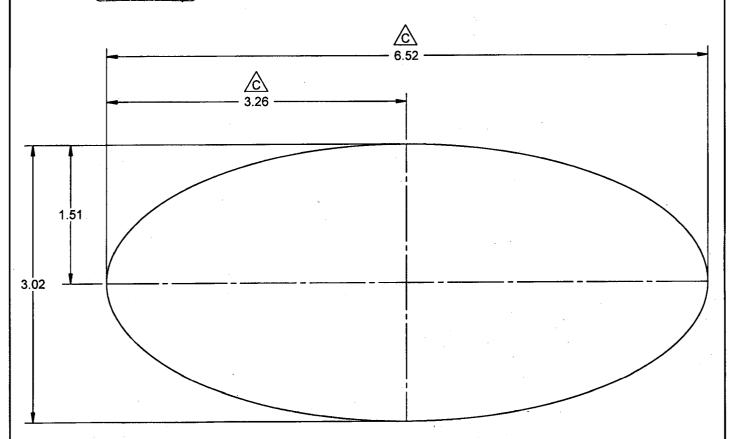
 REV
 DATE
 DESCRIPTION

 A
 98.04.16
 NEW ISSUE

 B
 02.12.18
 RE-DESIGN

 C
 06.10.05
 3.26 WAS 3.13; 6.52 WAS 6.27

RELEASED



D2744 CAP

NOTES: 1) MATERIAL:ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 COPY

(REF DART SPEC M6061T6S.080) OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016 RETURN TO ENGINEERING

(REF DART SPEC M5052H32S.080)

UNCONTROLLED COPY

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 5) BREAK ALL SHARP CORNERS

2) FINISH: NONE

SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER WORK ORDER

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